

Work Order ID 54677

December 16, 2009 10:26:01 AM



Page 1

Item ID: D4013-9

Accept



Setup Start



Revision ID:

Item Name: Stud

Stop



Start Date: 12/16/2009 Start Qty: 30.00



Cust Item ID:

Required Date: 12/21/2009 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date: 09-12-16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4013

C

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

turn as per Dwg and Folio FA860

Folio Rev: *2/1*

Dwg Rev: *2*

0.00

SA 09/12/19

Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

SA 09/12/19

30 *6*

30 *6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	MME 09/12/21			30	0		
130 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				9/12/21			300
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							09/12/21

C209/12/21

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Picklist Print

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Work Order ID: 54677



Parent Item: D4013-9



Parent Item Name: Stud

Start Date: 12/16/2009

Required Date: 12/21/2009

Comments: IPP REV:A NEW ISSUE 09-11-03 JLM VERIFIED BY:DD IPP
RevB: revC as per dwg 09.11.18 DD verified by:JLM

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R.500		Purchased	No				f	46.1150	4.0500			



304 SS roundbar .500



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	46.115	
108415	2	
111323	1.16	
113006	42.955	

4,421 SN 09/12/19

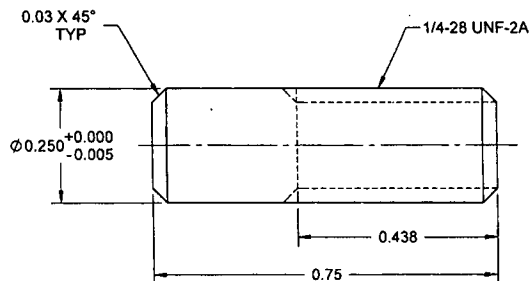
W/O:		WORK ORDER CHANGES					
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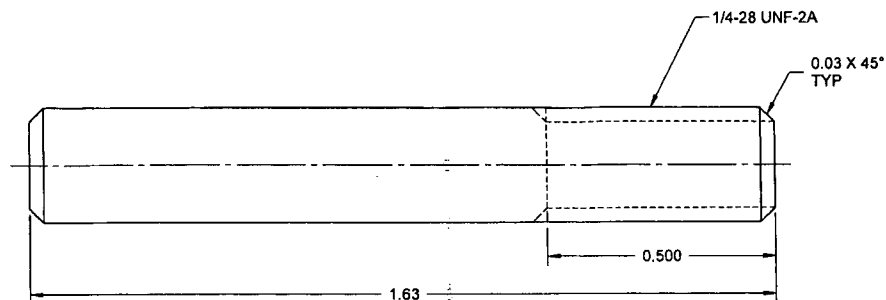
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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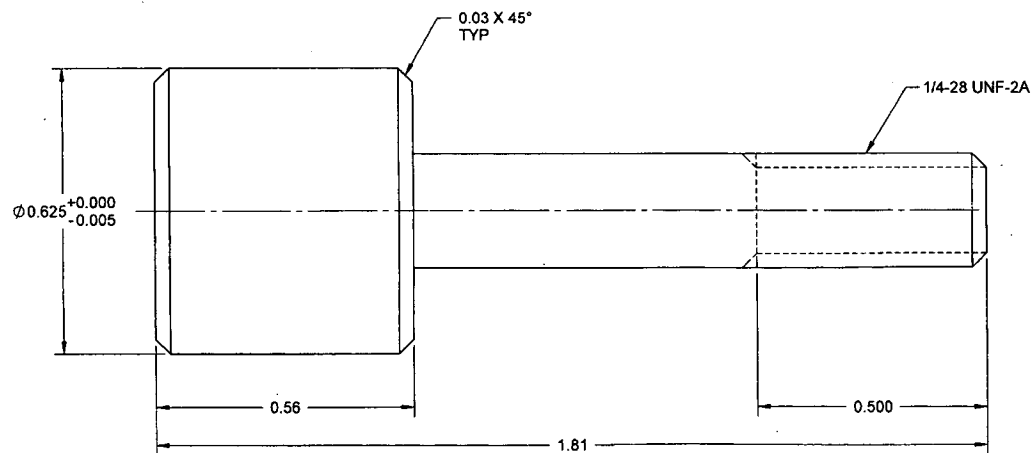
NOTE: Date & initial all entries



D4013-3 STUD



D4013-9 STUD



D4013-11 STUD

#54677

RELEASED
2009-11-24

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: LESS THAN 0.01 lbs EACH

DESIGN	JL	DART AEROSPACE LTD	
DRAWN	JL	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	DS	D4013	SHEET 4 OF 5
APPROVED	JA	TITLE	SCALE
DE APPR.	JA	WEARPLATE ASSEMBLY	NTS
DATE	09.11.11	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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